

Work Order ID 56700

March 4, 2010 12:43:17 PM

Page 1

Item ID: D3709-3

Accept

Setup Start

Revision ID:

Stop

Item Name: Angle

Start Date: 3/05/10 Start Qty: 5.00

Cust Item ID:

Required Date: 3/12/10 Req'd Qty: 5.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-3-04

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3709

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3709 □ Dwg Rev: A □ Prog Rev: A

□

****grain direction on a 45 degree ****

□ 2- Deburr if

necessary

6061 . 063

HB 10-3-10

8

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

HB 10-3-10

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8 10/3/10

HB

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56700

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Page 2

Item ID: D3709-3

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Start Date: 3/05/10

Start Qty: 5.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Form as per dwg D3709

So 10/04/19

8 8

140

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

8 10/04/19

(X8)

150

0.00



HandFinish

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

Hand Finishing

JL 10/04/20

8 8

W/O:		WORK ORDER CHANGES					
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Work Order ID 56700

March 4, 2010 12:43:23 PM



Page 3

Item ID: D3709-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Angle

Start Date: 3/05/10

Start Qty: 5.00



Cust Item ID:

Required Date: 3/12/10

Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

⑤ BP 10-4-20

170

Identify as per dwg & Stock Location: 83

0.00



Packaging

Memo

0.00

Packaging

10-4-21 TDS

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/22 JF

MF 10-4-22

W/O:		WORK ORDER CHANGES					
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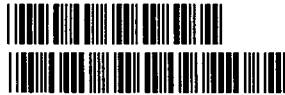
NOTE: Date & initial all entries

Picklist Print

March 4, 2010 12:40:33 PM

Page 231

Work Order ID: 56700



Parent Item: D3709-3

Parent Item Name: Angle

Start Date: 3/05/10

Required Date: 3/12/10

Comments: IPP Rev:A 08-10-31 new issue DD verified by:EC

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased	No				sf	295.7841	1.4000	2.3		



6061-T6 .063 Sheet



1210-3-10

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	295.7841211	
110551	18.1841211	
113608	277.6	

8

113608

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NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36700

10-3-04


D3709-3 ANGLE

D3709-1 ANGLE

RELEASED
02/05/04

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3709-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3709-1 = 0.24 lbs
D3709-3 = 0.16 lbs

A	NEW ISSUE	MB	08.05.02
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. A
CHECKED		D3709	SHEET 1 OF 3
MFG. APPR.		TITLE	SCALE
APPROVED		ANGLE	NTS
DE APPR.			
DATE		08.05.02	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD

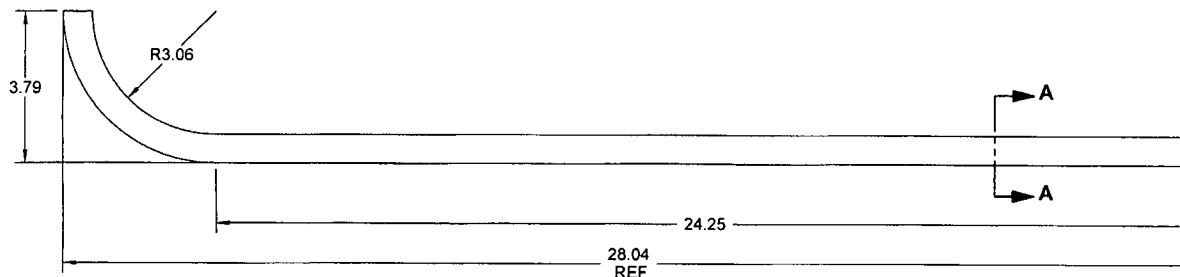
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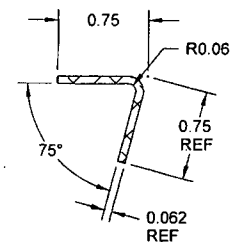
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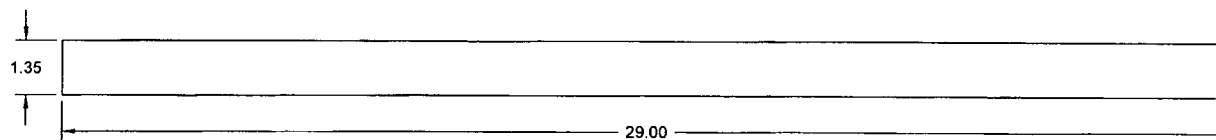
NOTE: Date & initial all entries



D3709-1 ANGLE
(MAKE FROM D3709-1F)



SECTION A-A
SCALE 2X



D3709-1F ANGLE FLAT PATTERN

GRAIN
DIRECTION

W/O 56700

RELEASED
09/04/09

DESIGN	15	DART AEROSPACE LTD	
DRAWN	15	HAWKESBURY, ONTARIO, CANADA	
CHECKED	15	DRAWING NO.	REV. A
MFG. APPR.	15	D3709	SHEET 2 OF 3
APPROVED	15	TITLE	SCALE
DE APPR.	15	ANGLE	NTS
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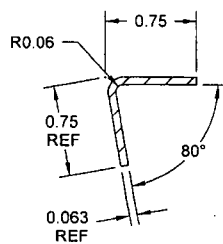
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

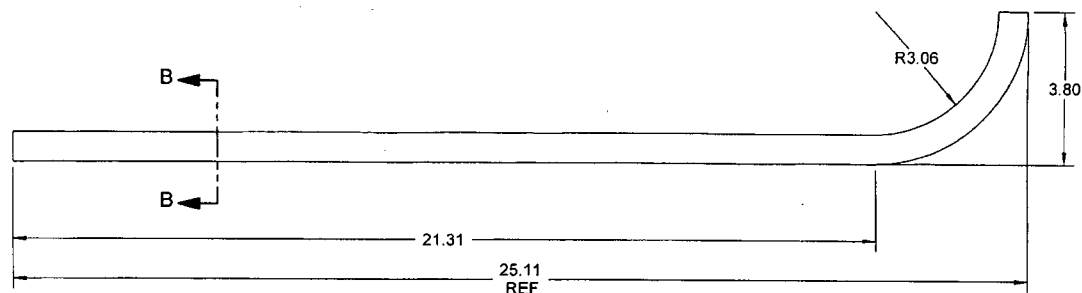
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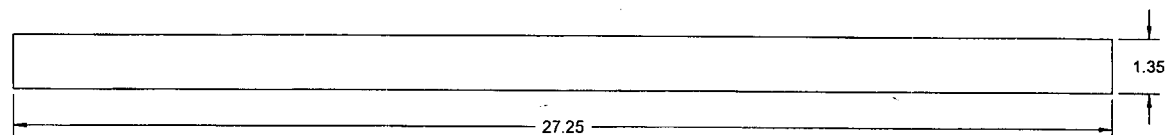


SECTION B-B
SCALE 2X



D3709-3 ANGLE
(MAKE FROM D3709-3F)

GRAIN
DIRECTION



D3709-3F ANGLE FLAT PATTERN

w/o 56700

RELEASED
07/04/09

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3709	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		ANGLE	NTS
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